

Work Order ID 56672

March 4, 2010 11:29:55 AM

Page 1

Item ID: D412-742-043

Accept

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 3/04/10 Start Qty: 1.00

Required Date: 3/12/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DC

DOCUMENT CONTROL

Document Control

Memo

0.00

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56672

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Page 2

Item ID: D412-742-043

Accept

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 3/04/10 Start Qty: 1.00

Required Date: 3/12/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 ☐ 112429
Expiry date: ☐ 10/08

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☐ 112429
Expiry date: ☐ 10/08

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R ☐ LPS Procyon ☐ 104251

BL 10-4-22

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56672

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Page 3

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 3/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PP 56675 10-4-27

10/04/27

ME 10-4-27

Picklist Print

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Page 1

Work Order ID: 56672

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

Start Date: 3/04/10

Required Date: 3/12/10

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 110 Each 1,333.000 24.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 114330 1333
 112314 13
 112720 12
 112724 3
 112829 1
 112991 2
 113121 64
 113226 344
 113644 294
 113749 100
 114103 500

24. BR 10-4-22

AN3C6A Purchased No 110 Each 730.0000 12.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 730
 111982 ✓ 730

12 BR 10-4-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 56672



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments:

IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C7A

Purchased No

110 Each

493.0000 8.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

493

105906

21

107376

252

113149

220

AN960C10L

Purchased No

110 Each

388.0000 44.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

Manufactured No

110 Each

0.0000 1.0000

D3391-021



Fwd Tube Assembly

pulled on

D 3391-023

456623

56495

8 BR 10-4-22

144. BR 10-4-22

1 BR 10-4-22

March 4, 2010 11:29:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 56672



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

* D3391-023

Mid Tube Assembly

Manufactured No 110 Each 2.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 56623 2

40522 1

53938 1

①

BL 10-4-22

* D3391-025

Aft Tube Assembly

Manufactured No 110 Each 3.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 56498 3

39129 1

48122 1

54703 1

①

BL 10-4-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 56672

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
 IPP Rev:C 07-05-28 As per Rev F
 IPP Rev:D 07-12-04 ECN 1072

KJ/JLM
 EC
 JLM
 DD verified by:JLM

Start Date: 3/04/10

Required Date: 3/12/10

Start Qty: 1.00

Required Qty: 1.00

D3564-1

Manufactured No

110

Each

19.0000

1.0000



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

33798

2

Main Warehouse

ST

17

47531

1

50270

1

51676

15

BR 10-4-22

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56672



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev: C 07-05-28 As per Rev F JLM
 IPP Rev: D 07-12-04 ECN 1072 DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-3 Manufactured No 110 Each 20.0000 1.0000



Wearshoe



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33764	2	
Main Warehouse		
FP	6	
50113	6	
Main Warehouse		
FP19	11	
55489	11	
Main Warehouse		
ST	1	
46445	1	

1 10-4-22

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 56672



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 110 Each 37.0000 1.0000



Wearshoe



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	33	
51925	1	
54772	7	
55024	12	
55333 ✓	13	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 PR 10-4-22

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56672



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 110 Each 25.0000 2.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP 57257	20	
52512	3	
54480	1	
55011	1	
55320	15	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

2 PL 10-4-22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 56672



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

110

Each

27.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19 56829

23

55026

11

55335

12

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

1 10-4-22

March 4, 2010 11:29:47 AM

Shop Packet Print

Page 8

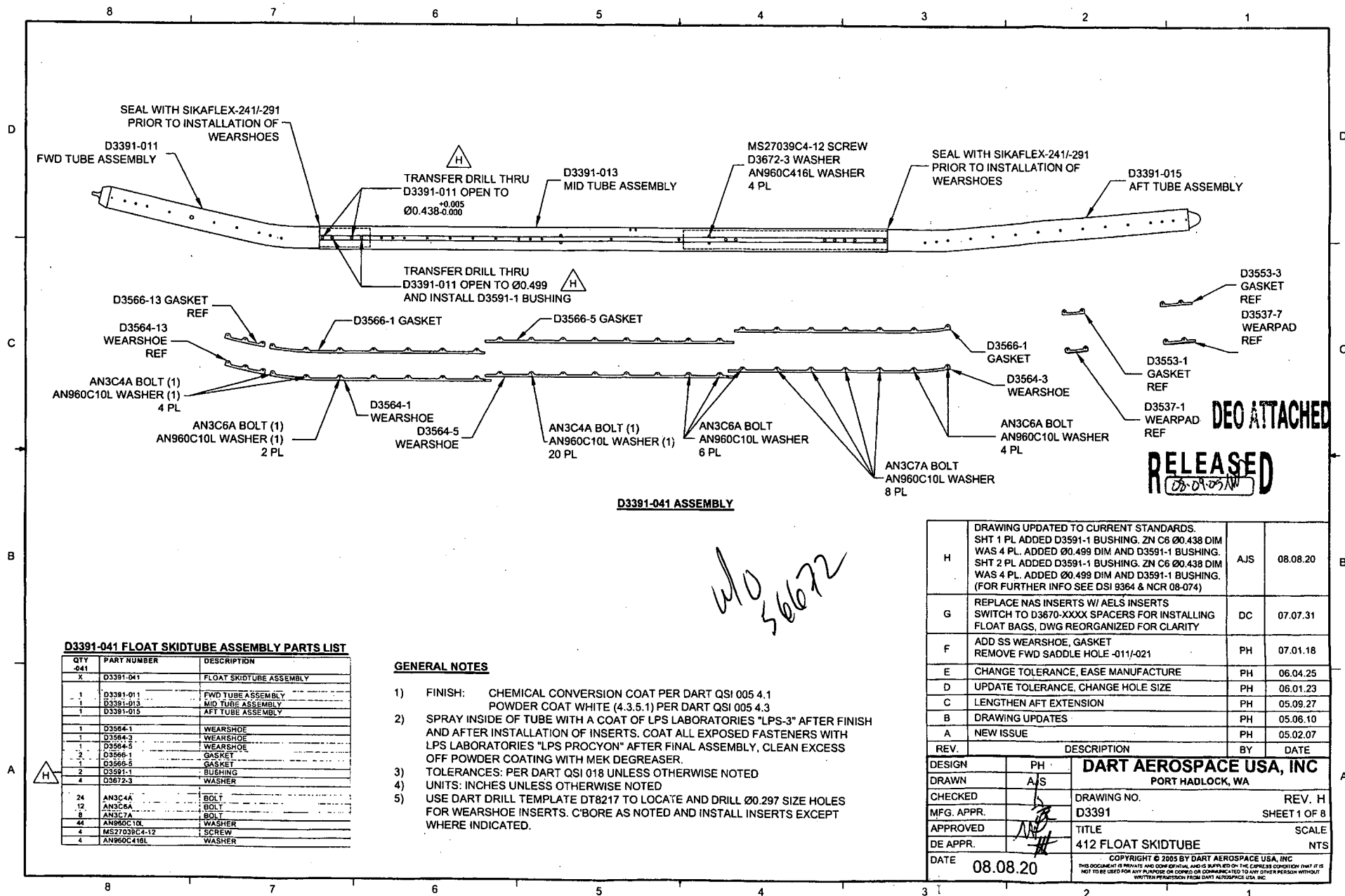
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

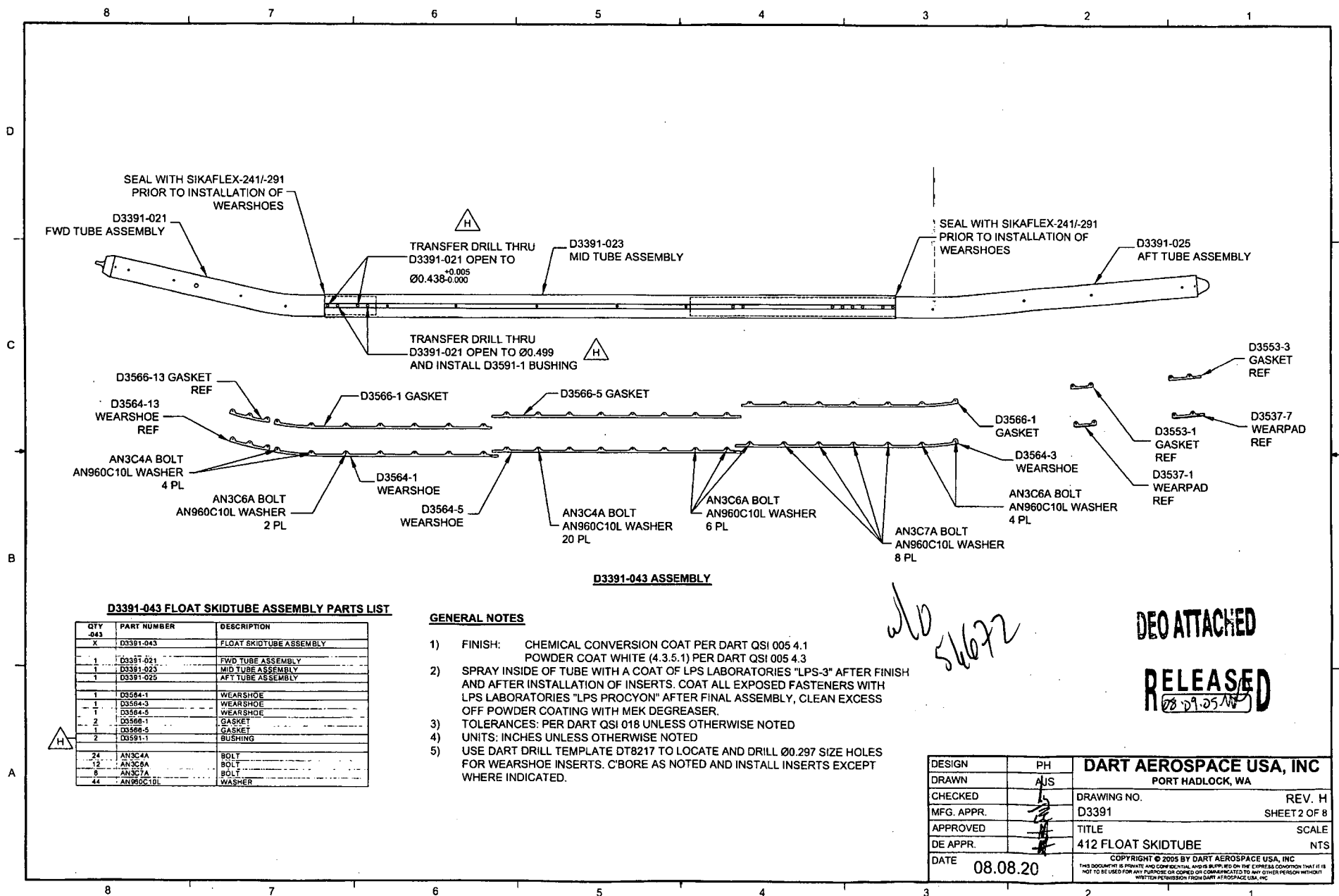
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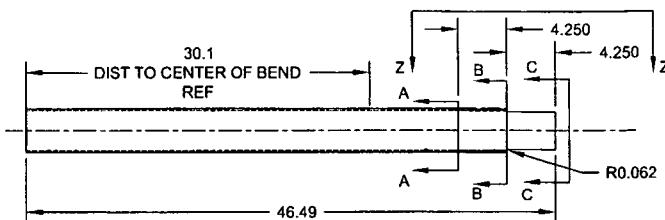
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

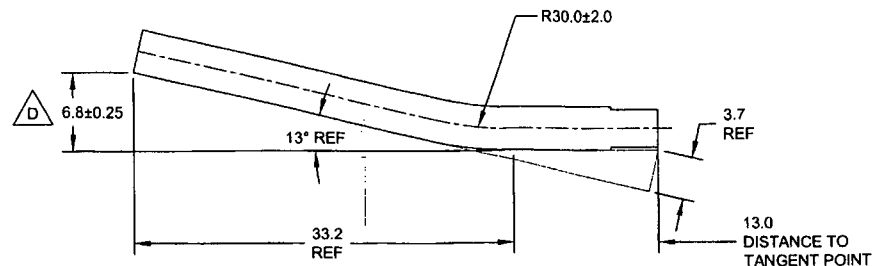
NOTE: Date & initial all entries



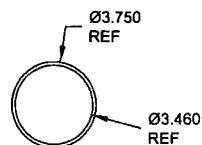




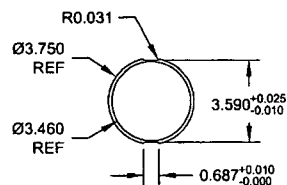
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



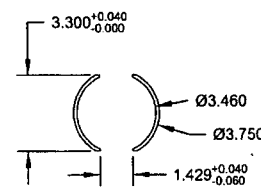
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



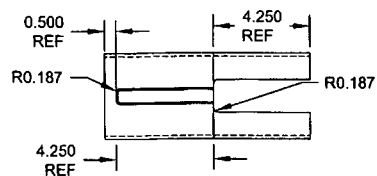
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



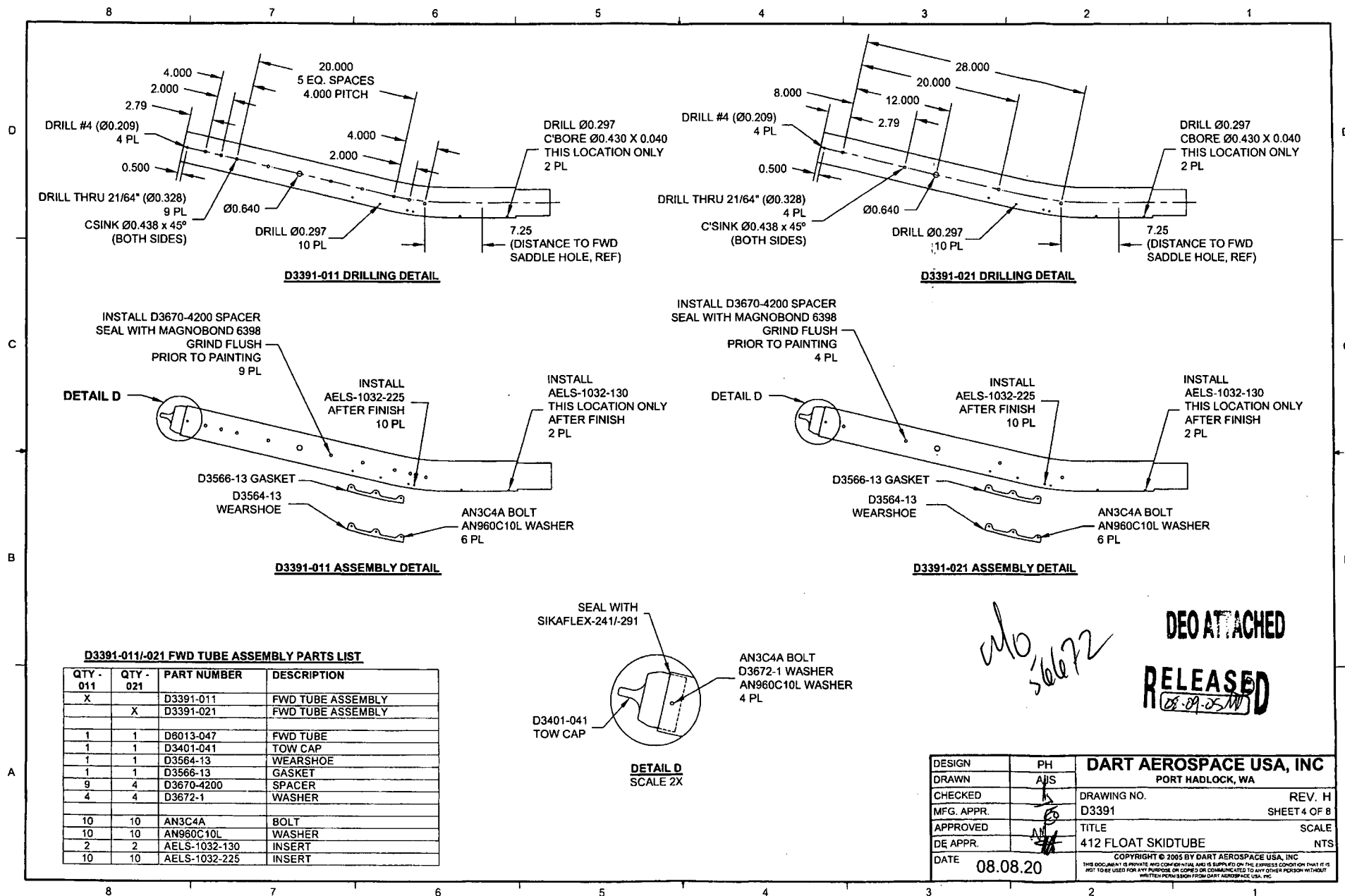
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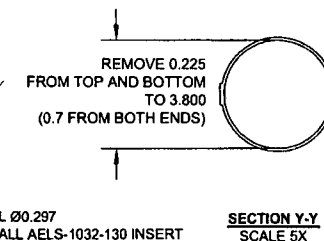
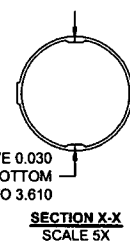
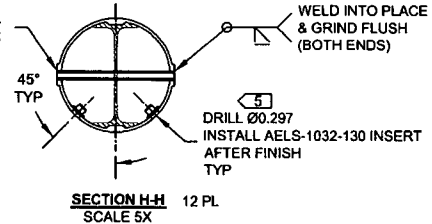
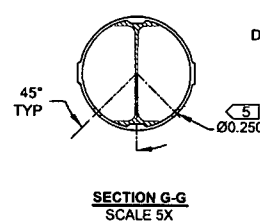
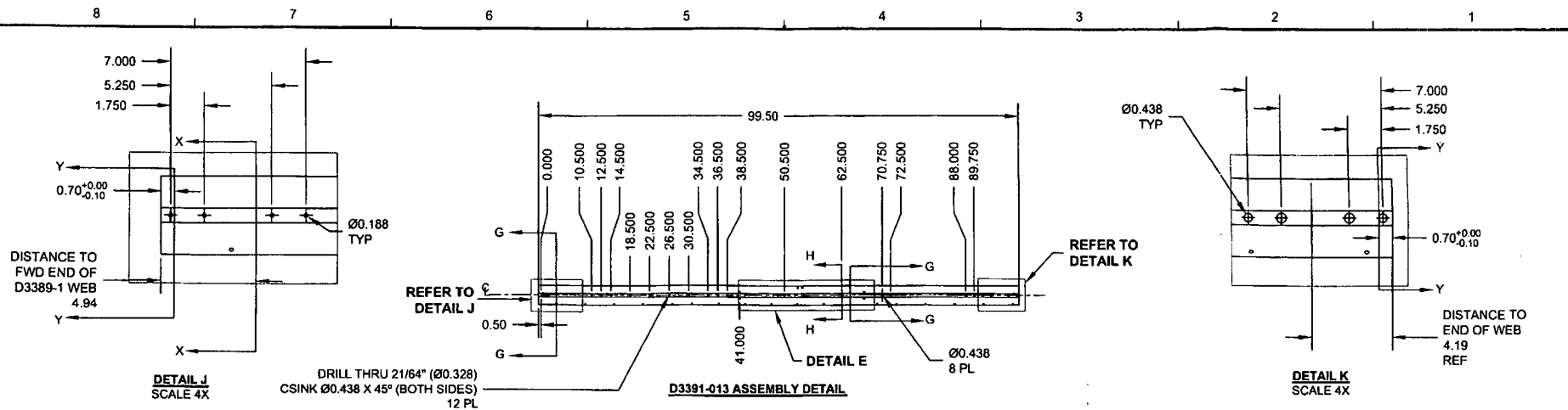


VIEW Z-Z
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

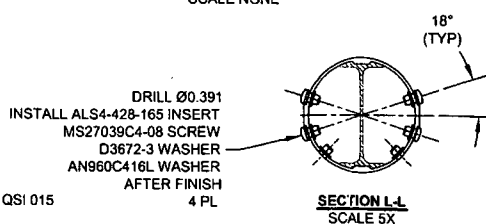
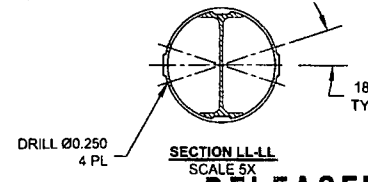
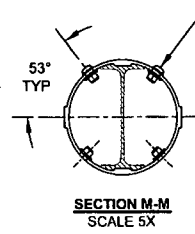
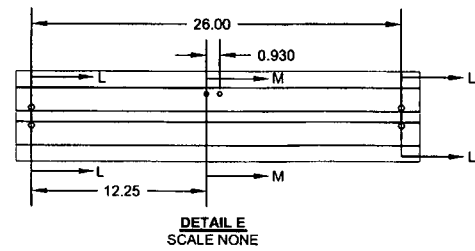
DEO ATTACHED
RELEASED
28 JAN 05





D3391-013 MID TUBE ASSEMBLY PARTS LIST

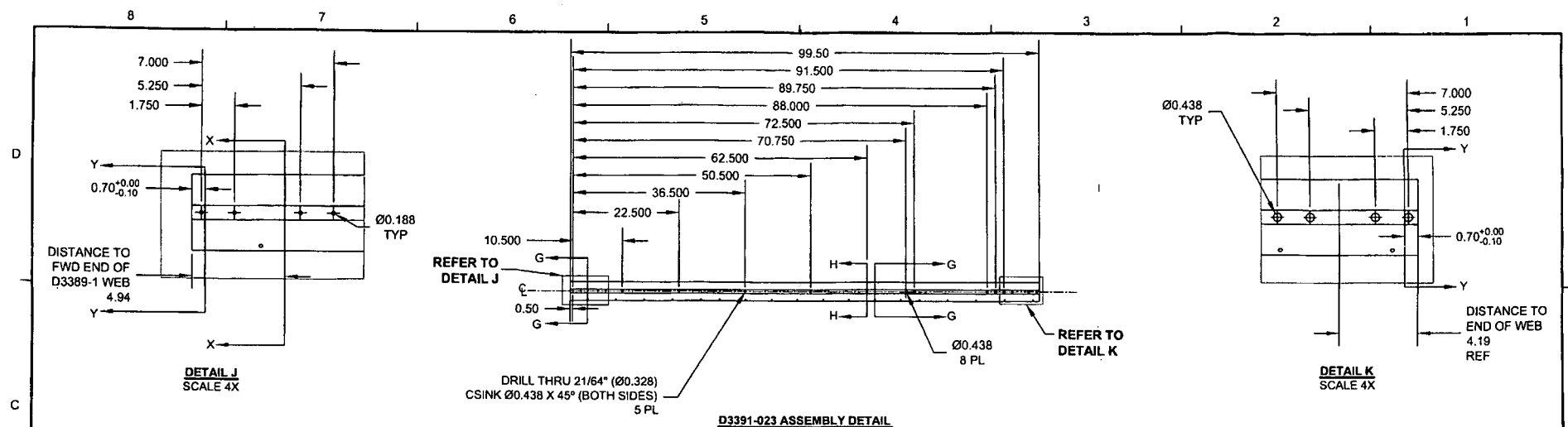
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



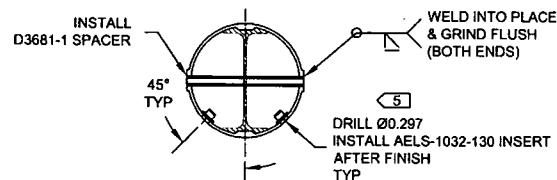
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

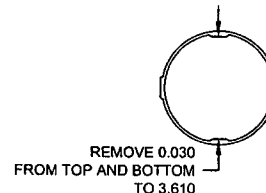
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.		SHEET 5 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



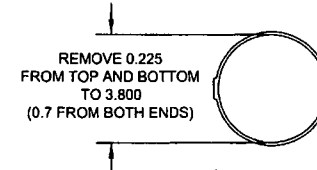
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

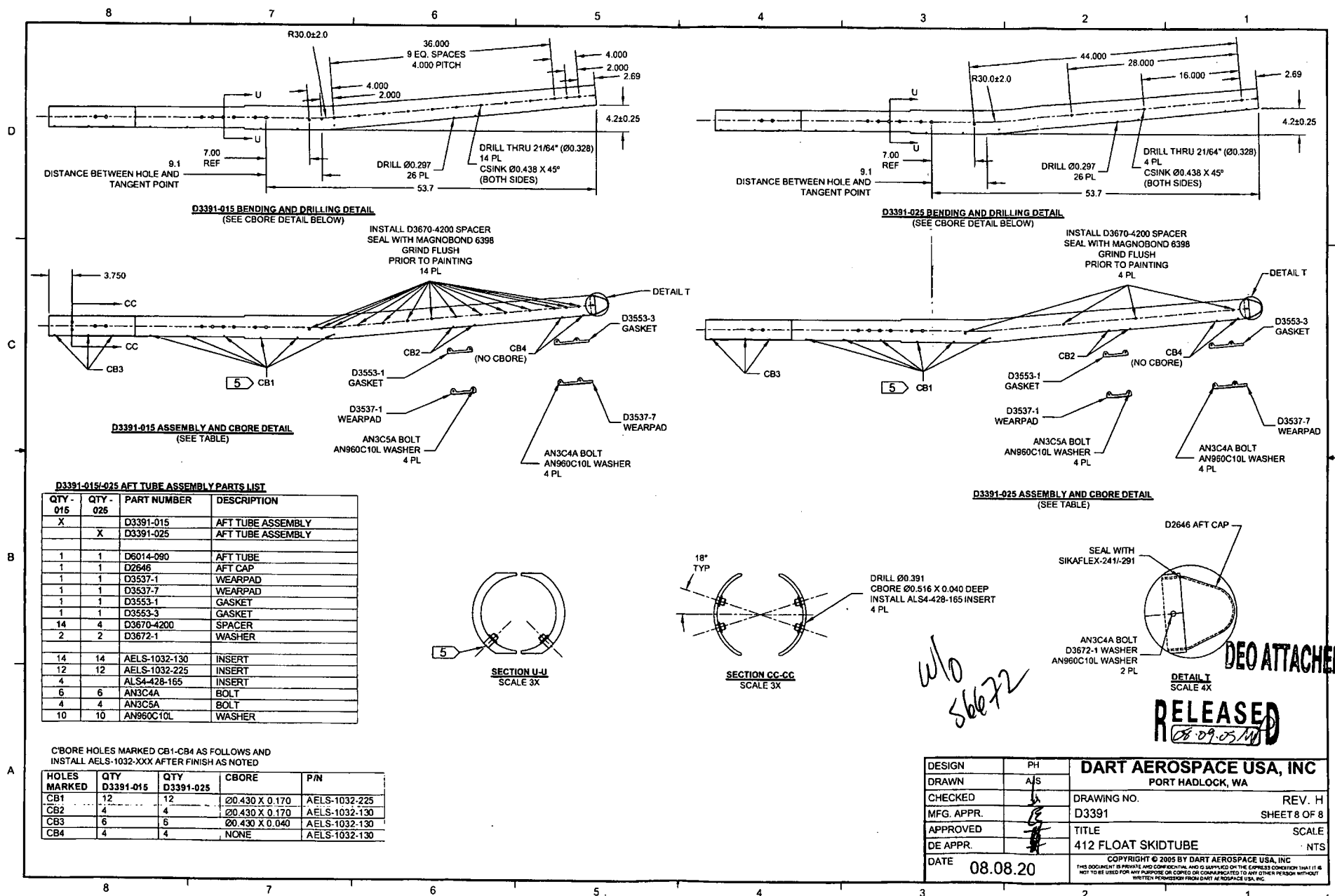
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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DEO ATTACHED
RELEASED
08-09-05-14



DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.23	DATE 06.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

1056072